

6661 .375 X .058

Work Order ID 86394***86394***

Page 1

Item ID: D2617-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 27/06/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/28

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2617

Rev D2

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA437 and Dwg D2617

12/07/11 30 0

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12/07/11 30 0

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

12.7.11 30 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86394

86394

Page 2

June-27-12 3:58:04 PM

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bushing

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30

Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Small Fab

Small Fab

0.00

PA 12.7.11

30 P

Memo

0.00

Small Fab

Deburr break all unmarked sharp edges 0.005 to 0.010

135

135

QC

QC5- Inspect part completeness to step on W/O

0.00

u/25

Memo

0.00

Quality Control

140

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

30 PA 12.7.12

W/O:		WORK ORDER CHANGES					
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Work Order ID 86394

86394

Page 3

June-27-12 3:58:04 PM

Item ID: D2617-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 27/06/2012 Start Qty: 30.00

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Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 30.00

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC3- Inspect Part Finish

0.00

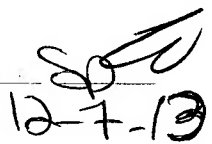
150

QC

Memo

0.00

Quality Control

30x  12-7-13

160 Identify as per dwg & Stock Location: STB

0.00

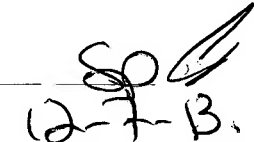
160

Packaging

Memo

0.00

Packaging

30x  12-7-13

170 QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 12/07/13

MLJ 12/07/13

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-27-12 3:58:08 PM

Work Order ID: 86394

86394

Parent Item: D2617-3

D2617-3

Parent Item Name: Bushing

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP G04.07.14Reformat; added step 5KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	397.0360	0.0729	2.302105			
M6061T6T0 375W 058										**	2.505'	12/07/11	
6061-T6 RD Tube .375 x.058W													

Location	Loc Qty	Loc Code
MAT014	397.036	
116920	0.578	
119087	8.56	
119376	270	
119678	66	
120633	51.898	

2.505'

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Dart Aerospace Ltd

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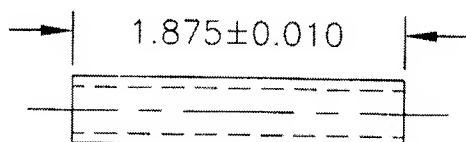
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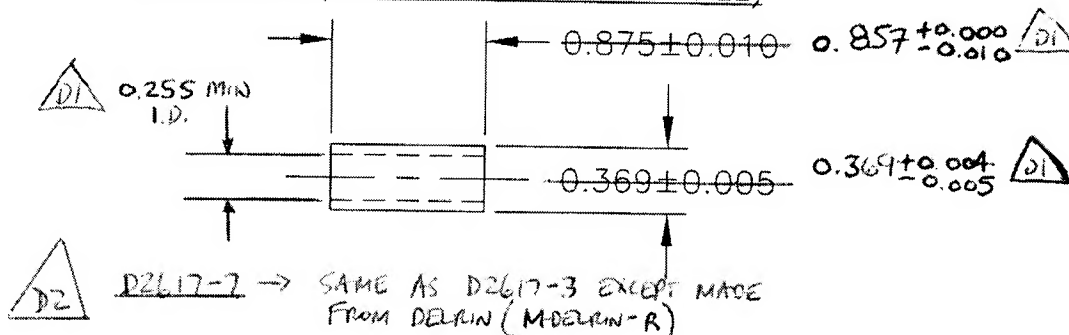


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04		TITLE BUSHING		SCALE 1:1
D2	04.04.10	CP	ADD D2617-7	A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				D1	04.07.12 CORRECT TOLERANCE (NCR 779)

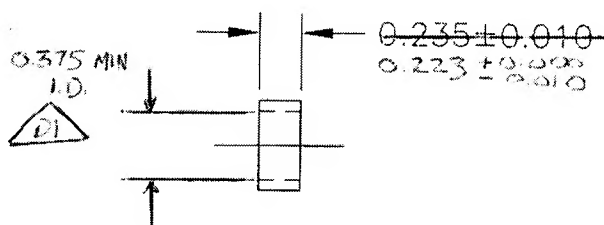
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 863214 MJS
12/06/28

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4) OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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